



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

Ship May 24
Order 5782
003436

648.4701
Job Sheet 176650



5

Part No: 648.4701

Job Qty: 1 ea

Part Name: C2 Overhaul Kit



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/26/18

Job Tracking No:

Due Date: 5/24/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG OM_OOPM-C2 Rev 4 IPP Rev A 18.03.07 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		5/24/18	0.00	0.00	Start Up Stores/Pkg-1		18-06-12
110	Small Fab	1 pcs		5/24/18	0.00	1.00	Small Fab-9		18-06-12
120	QC	1 pcs		5/24/18	0.00	0.00	QC4		38
125	DC	1 pcs		5/24/18	0.00	0.00	DC		9-88
130	Packaging	1 pcs		5/24/18	0.00	0.00	Packaging3-1		SRB 18-06-15
140	QC21-FG	1 Ea		5/24/18	0.00	0.00	QC21		DAS 21 9-88

Part Op 110 - Pick kit

Descriptions: 125 - Photocopy bluefile & type labels per PPP 648.7401

130 - Identify and pack for shipping as per PPP 648.4701

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
188-FPSS-1032-1/4	Set Screw	2 Ea (2 ea)	90-Start up Operation	5058750
600.1310-AP	Label	1 pcs (1 ea)	90-Start up Operation	5029482
600.1314P	C2 Caution Sticker	1 pcs (1 ea)	90-Start up Operation	5029484
AN3-14A	Bolt	1 Ea (1 ea)	90-Start up Operation	5067270
AN4-16A	Bolt	2 Ea (2 ea)	90-Start up Operation	5068654
AN4-17A	Bolt	1 Ea (1 ea)	90-Start up Operation	5070163
AN060-10 WAS 1149F0363P	Washer	1 Ea (1 ea)	90-Start up Operation	5027738
AN060-10 WAS 1149F0332P	Washer, #10	4 Ea (4 ea)	90-Start up Operation	5068663
AN060-11 WAS 1149F0463P	Flat Washer Dia 1/4"	6 Ea (6 ea)	90-Start up Operation	5056461
C2-12-1	Lock Bushing missing 1	2 Ea (2 ea)	90-Start up Operation	5029234
C2-12-7P	Teflon Spacer Lock	2 pcs (2 ea)	90-Start up Operation	5029236
C2-12-8	DUST SHEILD - C2 HOOK	2 Ea (2 ea)	90-Start up Operation	5075404
C2-13-5	Keeper Spring	1 (1 ea)	90-Start up Operation	5075033
C2-14-2	Label Rivets	4 Ea (4 ea)	90-Start up Operation	5057170
C2-3-1	Bearing DU	2 pcs (2 ea)	90-Start up Operation	5068886
C2-3-2-1	Roller Pin Retaining Ring	2 Ea (2 ea)	90-Start up Operation	5056845
C2-3-3-1	Latch Roller DU Bearing	1 Ea (1 ea)	90-Start up Operation	5050472
C2-3-5	Spacer, Teflon	2 Ea (2 ea)	90-Start up Operation	5058758
C2-3-8	Actuator Bushing	2 Ea (2 ea)	90-Start up Operation	5072543
C2-4-1	Trunnion Bushing	2 (2 ea)	90-Start up Operation	5075145
C2-7-1P	Load Beam Bumper	1 pcs (1 ea)	90-Start up Operation	5029255
C2-7-2	Lock Bumper	2 Ea (2 ea)	90-Start up Operation	5076396

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

346
20
07-1



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
				Completed By					
				Lead hand / Supervisor Approval Verification					
				QC / QA Coordinator Approval					

Root Cause				FAULT CATEGORY			
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
				Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
				Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
				Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
				Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
				Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
				Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
				Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
				OTHER : _____			

C2-9-3	Clock Spring Cover Screw ~	4 Ea (4 ea)	90-Start up Operation	5061527
C3-10-2	Lock Spring ~	1 Ea (1 ea)	90-Start up Operation	5070352
C3-3-4-1	Ring, Retaining ✓	4 pcs (4 ea)	90-Start up Operation	5070542
C3-3-9 P	Actuator Spring ~	1 pcs (1 ea)	90-Start up Operation	5029280
C3-8-4	Solenoid Cover Gasket ~	1 pcs (1 ea)	90-Start up Operation	5079782
MS21044N4	Nut, Self-Locking ~	3 Ea (3 ea)	90-Start up Operation	5061119
MS21083N3	Nut ~	3 Ea (3 ea)	90-Start up Operation	5036469
MS35266-63	Solenoid Cover Screw ~	1 Ea (1 ea)	90-Start up Operation	5038767
MS35338-137	Washer ~	4 Ea (4 ea)	90-Start up Operation	5050160

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	188-FPSS-1032-1/4	2	104	0
	600.1310-AP	1	34	0
	600.1314P	1	60	0
	AN3-14A	1	78	0
	AN4-16A	2	239	0
	AN4-17A	1	163	0
	AN960-10	1	3,363	0
	AN960-10L	4	0	0
	AN960-416	6	0	0
	c2-12-1	2	0	0
	C2-12-7P	2	258	0
	C2-12-8	2	0	0
	C2-13-5	1	0	0
	C2-14-2	4	264	0
	C2-3-1	2	0	0
	C2-3-2-1	2	100	0
	C2-3-3-1	1	29	0
	C2-3-5	2	100	0
	C2-3-8	2	6	0
	C2-4-1	2	0	0
	C2-7-1P	1	119	0
	C2-7-2	2	0	0
	C2-9-3	4	50	0
	C3-10-2	1	0	0
	C3-3-4-1	4	62	0
	C3-3-9	1	0	0
	C3-8-4	1	0	0
	MS21044N4	3	158	0
	MS21083N3	3	87	0
	MS35266-63	1	44	0
	MS35338-137	4	578	0

Part Specifications

Specifications could not be found.



QA Closed: _____ Date: _____

Work Order update only

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No. _____		Rework ☐		Skid-tube ☐		Cross tube ☐		Water Jet ☐		Engineering ☐	
NCR No. _____		Scrap ☐		Machining ☐		Small Fab ☐		Prod. Eng. Coord. ☐		Quality ☐	
Date : _____		Use-as-is ☐		Thermoforming ☐		Finishing ☐		Rec/Store/Packaging ☐		Other ☐	
Description W										MRB (QSI042) Approval	
										Completed By	
										Lead hand / Supervisor Approval Verification	
										QC / QA Coordinator Approval	
Uart Aerospace Ltd. 1270 Aberdeen Street Hewesbury, ON K64 1K7 CANADA TEL.: 1 813 832-5200 Email: sales@dartaero.com www.dartaerospace.com DART AEROSPACE Container No: S080103 Part: 648.4701 Job No: 176650 Serial No/Batch: S080103 Revision: 4 Inspector: Exp Date: Instructions: Date: 06/12/18											
Root Cause											
Environment	☐	No Re-verifica	☐	Centre Not Concentric	☐	Broken/Damage/Defect	☐	Weld	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Cracks	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Crimp/Kink/Ripple/Wave	☐	Contamination	☐	Out of Sequence	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cuffs	☐	Countersink	☐	Off-set	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crushing	☐	Cut Too Short	☐	Mislabeled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Heat Treat	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Wave/Twist in Tube	☐	Drill Holes	☐	Misaligned/off center	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Marks/Chatter	☐					Finish	☐
LOA	☐	Product Improvement	☐							Misread	☐
Substation	☐	Process Improvement	☐							Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐								
Misidentified	☐	Past Due	☐	OTHER :							